

Work Order ID 136502

September 02, 2015 3:03:25 PM

136502

Page 1

Item ID: D4030-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Assembly (350)
 Start Date: 9/1/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/1/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: 56 Date: 20150903 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4030	D								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
110									
HandFinish	Memo	0.00							
Hand Finishing									
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

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38
9-29

1 of 21 sticks

38
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID: 136502

136502

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 9/1/2015

Required Date: 9/1/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC IPP Rev D 12.03.27 per NCR12-1239 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530		Manufactured	No			100	Each	2.0000	1	1			DWG 6 9.09
D2530									**	132393			
Handle Weldment													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST379				2					
				115580				2					
D2535		Manufactured	No			100	Each	60.0000	2	2			DWG 6 9.09
D2535									**	137337			
Spring													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST007				1					
				124521				1					
				ST008				59					
				131996				9					
				134782				50					
D2537		Manufactured	No			100	Each	50.0000	2	2			DWG 6 9.09
D2537									**	135535			
Bushing													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST008				50					
				113174				2					
				123463				7					
				131896				1					
				132664				20					
				134935				20					

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Work Order ID: 136502

136502

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 9/1/2015

Required Date: 9/1/2015

Start Qty: 1.00

Required Qty: 1.00

D3913-041

Manufactured No

100

Each

0.0000

1

1

D3913-041

Long Basket Base Assembly, 350

**

B13648661 11/15/15

D3914-041

Manufactured No

100

Each

0.0000

1

1

D3914-041

Long Basket Lid Assembly (350)

**

B13648661 11/15/15

D3917-3

Manufactured No

100

Each

41.0000

6

6

D3917-3

Washer

**

136542



Location

Loc Qty

Loc Code

ST065

41

121801

1

128455

16

133951

24

D3953-3

Manufactured No

100

Each

24.0000

2

2

D3953-3

Gas Spring Stud, Lid

**

136645

Location

Loc Qty

Loc Code

ST069

4

124029

3

131922

1

ST077A

20

122668

10

131080

6

132707

4



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Work Order ID: 136502

136502

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 9/1/2015

Required Date: 9/1/2015

Start Qty: 1.00

Required Qty: 1.00

D3953-7	Manufactured	No	100	Each	54.0000	2	2	DAS 6 9-09
D3953-7						**		
Spring Spacer								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST069	54	
120351	4	
121813	6	
130996	16	
131859	12	
135499	16	

D3953-9	Manufactured	No	100	Each	32.0000	2	2	DAS 6 9-09
D3953-9						**	135544	
Gas Spring Washer								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST069	32	
131057	22	
132672	10	

D3953-17	Manufactured	No	100	Each	26.0000	2	2	DAS 6 9-09
D3953-17						**	137904	
Gas Spring Spacer								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST070	26	
115708	4	
129797	10	
132522	12	

D3953-19	Manufactured	No	100	Each	23.0000	1	1	DAS 6 9-09
D3953-19						**		
Gas Spring Bracket								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST070	23	
118893	5	
131776	18	

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Work Order ID: 136502

136502

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 9/1/2015

Required Date: 9/1/2015

Start Qty: 1.00

Required Qty: 1.00

D3953-21

Manufactured No

100

Each

47.0000

1

1

D3953-21

Gas Spring Bracket

Location

Loc Qty

Loc Code

ST070

47

117496

3

128883

16

132602

28

D3969-3

Manufactured No

100

Each

23.0000

1

1

D3969-3

Prop

Location

Loc Qty

Loc Code

ST365

23

115924

8

133104

5

135397

10

AN3-14A

Purchased No

100

Each

127.0000

4

4

AN3-14A

Bolt

Location

Loc Qty

Loc Code

ST338a

100

m132825

100

ST348

27

m132680

27

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Work Order ID: 136502

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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 9/1/2015

Required Date: 9/1/2015

Start Qty: 1.00

Required Qty: 1.00

AN3-16A Purchased No

100 Each 95.0000 2 2

AN3-16A

Bolt

Location

Loc Qty

Loc Code

GA

45

117441

45

ST348

50

M133011

50

AN5-17A Purchased No

100 Each 144.0000 4 4

AN5-17A

Bolt

Location

Loc Qty

Loc Code

GA

36

117872

36

ST299A

100

m132317

50

m133077

50

ST337

8

125388

8

AN4-12 Purchased No

100 Each 67.0000 3 3

AN4-12

Bolt

Location

Loc Qty

Loc Code

ST325A

20

m128813

20

ST344

47

m132317

47

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D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 9/1/2015

Required Date: 9/1/2015

Start Qty: 1.00

Required Qty: 1.00

AN310-4 Purchased No

100 Each 97.0000 3 3

AN310-4

Nut

**

DAS

6

9-09

Location

Loc Qty

Loc Code

GA

25

M127815

25

ST331

72

M132382

72

3

AN310C4 Purchased No

100 Each 62.0000 2 2

AN310C4

Nut

**

DAS

6

9-09

Location

Loc Qty

Loc Code

ST331

62

M131305

12

M132344

50

2

MS21042L3 Purchased No

100 Each 818.0000 6 6

MS21042L3

Nut

**

133498

DAS

6

9-09

Location

Loc Qty

Loc Code

FP001

384

M130922

384

GA

227

M131317

227

ST305

207

116549

12

126333

49

M128754

2

M132123

17

M132382

2

M132883

17

M132930

108

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D4030-041

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Required Date: 9/1/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

100

Each

539.0000

4

4

MS21042L5

Nut

Location

Loc Qty

Loc Code

GA

146

m127813

146

ST260a

345

m132677

345

ST305

48

m127813

19

m131340

21

m132123

8

MS24665-151

Purchased

No

100

Each

164.0000

3

3

MS24665-151

Cotter Pin

Location

Loc Qty

Loc Code

GA

59

m128401

59

ST294

105

m128401

9

m129909

96

MS24665-300

Purchased

No

100

Each

139.0000

2

2

MS24665-300

COTTER PIN

Location

Loc Qty

Loc Code

GA

30

118234

30

ST293

109

M128812

109

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D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 9/1/2015

Required Date: 9/1/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P

Purchased

No

100

Each

954.0000

6

6

NAS1149F0432P

WASHER

Location

Loc Qty

Loc Code

ST260a

500

M132551

500

st268

454

M128995

63

M130388

8

M132677

383

NAS1149F0563P

Purchased

No

100

Each

125.0000

4

4

NAS1149F0563P

Washer

Location

Loc Qty

Loc Code

ST267

25

121350

25

st268

100

m132344

100

NAS1149F0332P

Purchased

No

100

Each

1,499.000

8

8

NAS1149F0332P

Washer

Location

Loc Qty

Loc Code

GA

210

122063

210

ST260a

1196

m128401

6

m131026

80

m131697

110

m133077

1000

st268

93

123900

7

m130388

86

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Start Date: 9/1/2015

Required Date: 9/1/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

100

Each

1,597.000

2

2

NAS1149C0432R

WASHER

Location

Loc Qty

Loc Code

GA

1586

m125807

476

m131467

1110

ST271

11

m131452

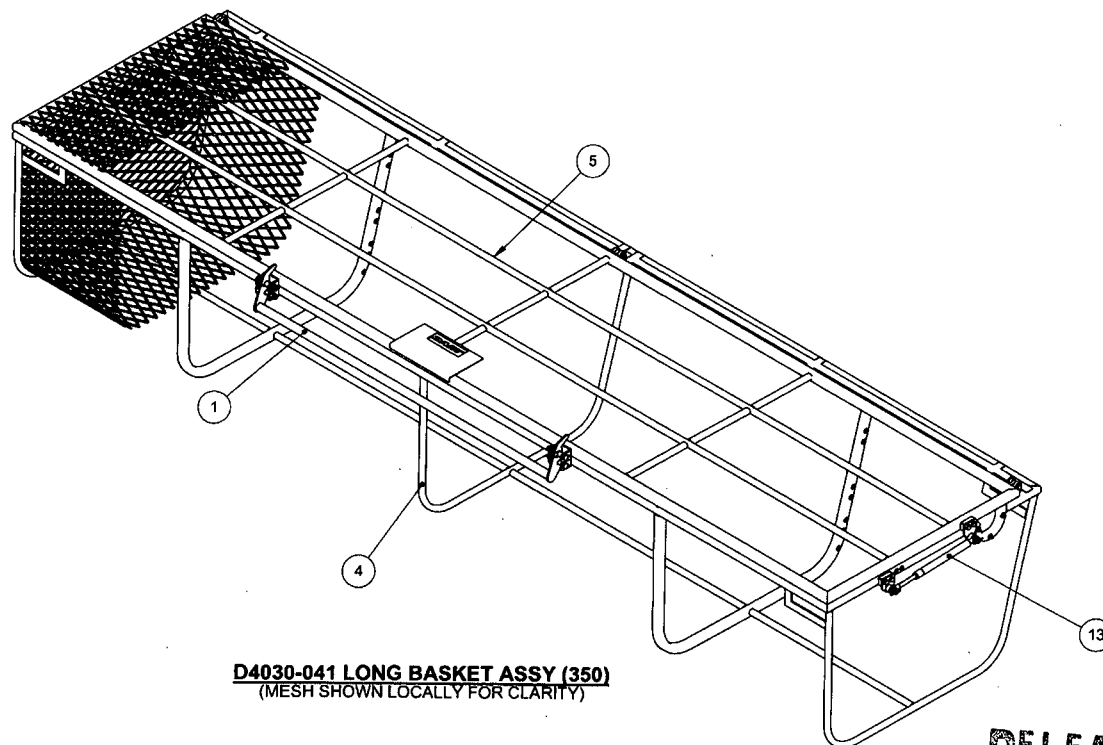
11

2

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D4030-041
6
8-8

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4030-041	LONG BASKET ASSY (350)
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	D3914-041	LONG BASKET LID ASSY (350)
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14	4	AN3-14A	BOLT, MACHINE
15	2	AN3-16A	BOLT, MACHINE
16	3	AN4-12	BOLT, MACHINE
17	4	AN5-17A	BOLT, MACHINE
18	2	AN310C4	NUT, PLAIN, CASTELLATED
19	3	AN310-4	NUT, PLAIN, CASTELLATED
20	6	MS21042L3	NUT, SELF-LOCKING
21	4	MS21042L5	NUT, SELF-LOCKING
22	2	MS24665-300	COTTER PIN
23	3	MS24665-151	COTTER PIN
24	2	NAS1149C0432R	WASHER
25	6	NAS1149F0432P	WASHER
26	8	NAS1149F0332P	WASHER
27	4	NAS1149F0563P	WASHER



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: 72 lbs APPROX

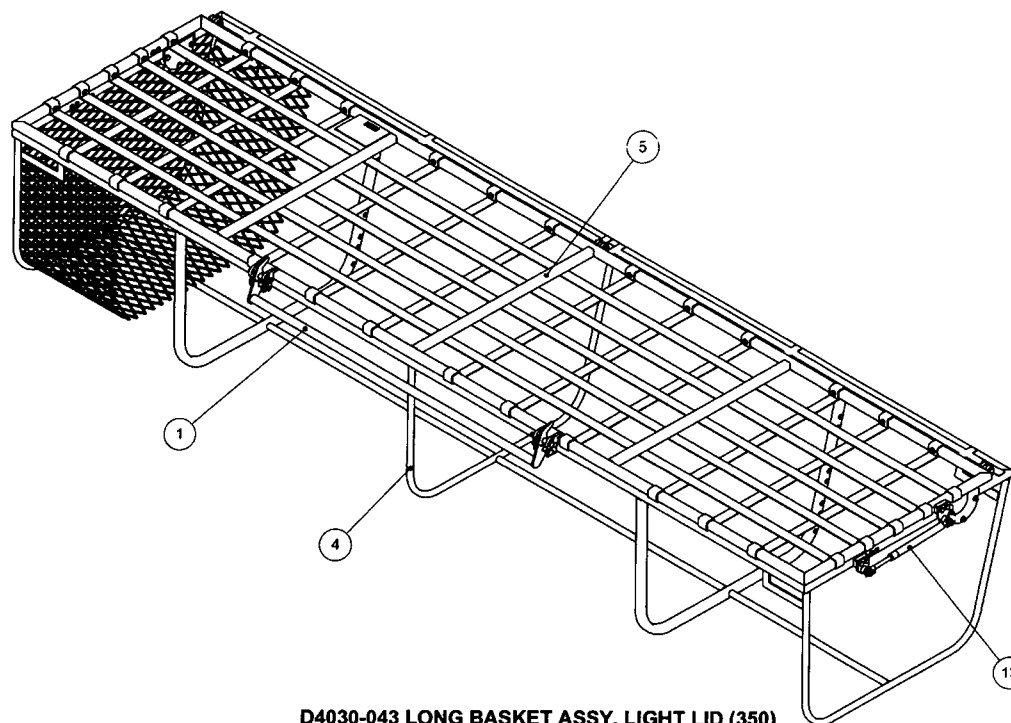
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 2013-08-16

D	REFORMAT FOR CLARITY. PICTORIAL UPDATE TO MULTIPLE VIEWS DUE TO CHANGES IN SUB ASSEMBLIES.	AJS	13.07.18
C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D8-1). ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4030	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY	P/N	DESCRIPTION
	X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	D3915-041	LIGHT LID ASSY, LONG BASKET
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14	4	AN3-14A	BOLT
15	2	AN3-20A	BOLT
16	3	AN4-12	BOLT
17	2	AN5-17A	BOLT
18	2	AN5-21A	BOLT
19	3	AN310-4	NUT, PLAIN, CASTELLATED
20	2	AN310C4	NUT, PLAIN, CASTELLATED
21	6	MS21042L3	NUT, SELF-LOCKING
22	4	MS21042L5	NUT, SELF-LOCKING
23	3	MS24665-151	COTTER PIN
24	2	MS24665-300	COTTER PIN
25	6	NAS1149F0432P	WASHER
26	4	NAS1149F0563P	WASHER
27	8	NAS1149F0332P	WASHER
28	2	NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

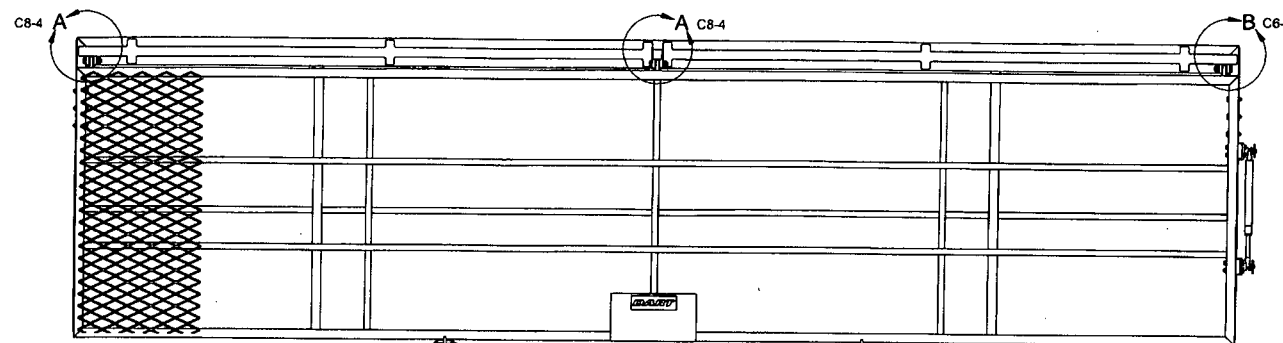
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2013-08-16
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NOTES:

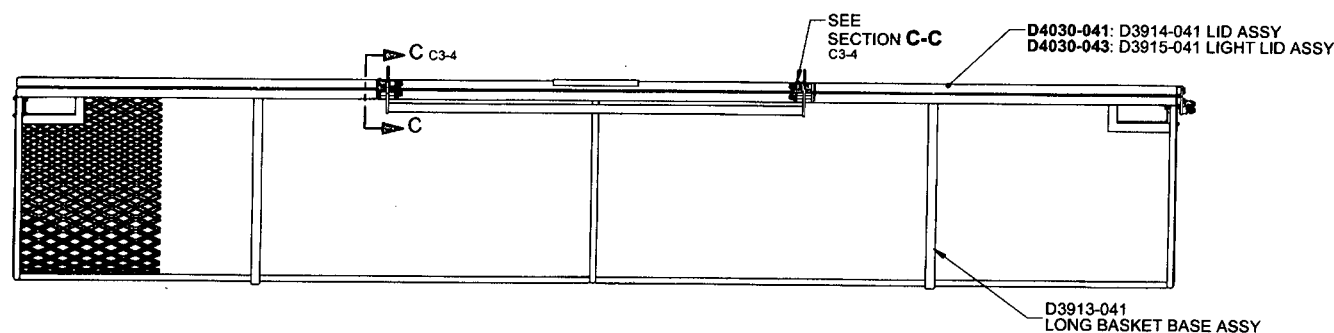
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 57 lbs APPROX

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4030	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET ASSY (350)	NTS
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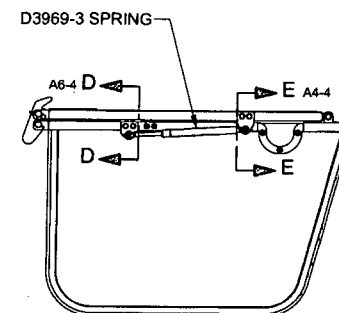


D2530
HANDLE WELDMENT



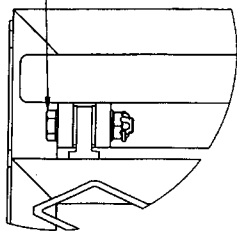
D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350) (SIMILAR)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

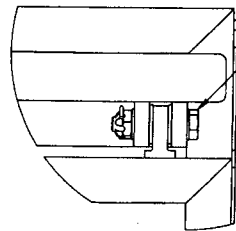


DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4030	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
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AN4-12 BOLT, MACHINE
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



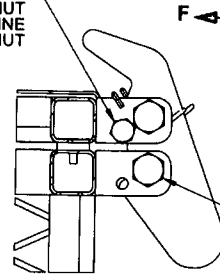
DETAIL A
D8-3
D5-3



DETAIL B
D3-3

AN4-12 BOLT, MACHINE
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

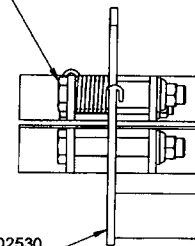
D4030-041: AN3-16A BOLT, MACHINE
MS21042L3 NUT
D4030-043: AN3-20A BOLT, MACHINE
MS21042L3 NUT



SECTION C-C
B4-3
B6-3

D4030-041: AN5-17A BOLT, MACHINE
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT
D4030-043: AN5-21A BOLT, MACHINE
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT, MACHINE
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

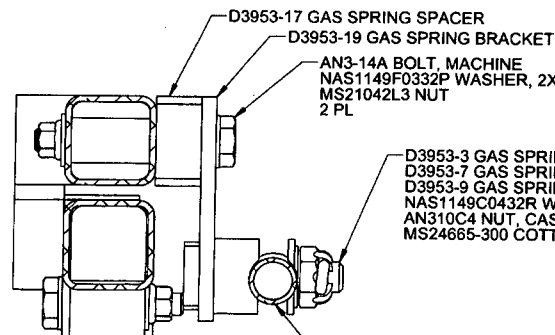
VIEW F-F
C3-4

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT, MACHINE
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D
B2-3



SECTION E-E
B1-3

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

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2013-08-16
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DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D4030	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
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